

Work Order ID 67241

Monday, March 14, 2011 10:14:23 AM

BLUE



Page 1

Item ID: D206-628-022BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step RH, Blue

Start Date: 3/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/03/14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D206-628	F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-022BL CHG 003

8/16/26

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/14/29 SL 20

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/16/26

72
217

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67241

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-022BL Location: _____ PPP Rev: _____								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/5/30 26

11/5/30

MF
11-05-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 14, 2011 10:14:20 AM

Page 1

Work Order ID: 67241

Parent Item: D206-628-022BL

Parent Item Name: Heli-Access-Step RH, Blue

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevF: add D2724-042 DD 09.11.17 verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A		Purchased	No				Each	259.0000	74	8			
---------	--	-----------	----	--	--	--	------	----------	----	---	--	--	--



Bolt

Location

Loc Qty

Loc Code

ST357

259

113359

3

114752

1

116419

9

116786

146

116914

100

AN4-15A

Purchased

No



Bolt

Location

Loc Qty

Loc Code

ST308

316

116786

316

ST358

14

114784

9

115108

5

AN960JD416

NAS1149D0463J

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

M117013

M117313

M117065 11/4/29 S/P20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Page 2

Monday, March 14, 2011 10:14:20 AM

Work Order ID: 67241

Parent Item: D206-628-022BL

Parent Item Name: Heli-Access-Step RH, Blue

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 2.00

Required Qty: 2.00

D2724-042 Manufactured No

Each 0.0000



206L Step Assembly

D2731-7 Manufactured No

Each 42.0000



Mounting Lug

Location

Loc Qty

Loc Code

ST470

42

61653

1

62929

41

D2732-030 Manufactured No

Each 18.0000



Rubber Cushion

Location

Loc Qty

Loc Code

ST409

18

65395

18

D3394-043 Manufactured No

Each 60.0000



Lug Assembly

Location

Loc Qty

Loc Code

ST475

60

62930

30

62976

30

71 1 2
67243
8
B59177 11/5/26

16
B64283 11/4/29

8
B69180 11/5/26

Monday, March 14, 2011 10:14:20 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 3

Work Order ID: 67241

Parent Item: D206-628-022BL

Parent Item Name: Heli-Access-Step RH, Blue

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

Each

4,370.000

24



Nut



11/4/29 SD 20

Location

Loc Qty

Loc Code

ST300

4370

1123143

2

115589

10

115621

20

116188

2338

116823

2000

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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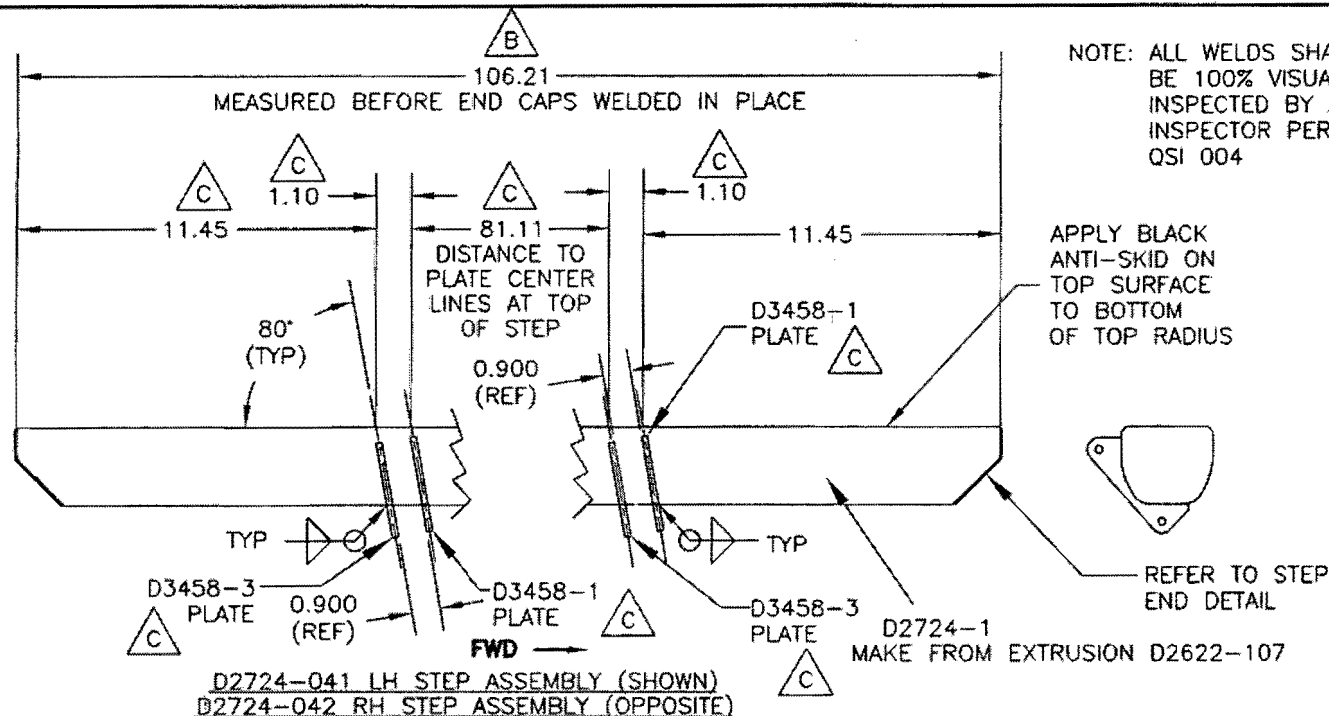
NOTE: Date & initial all entries

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	AN960JD416	WASHER
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

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NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

— REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

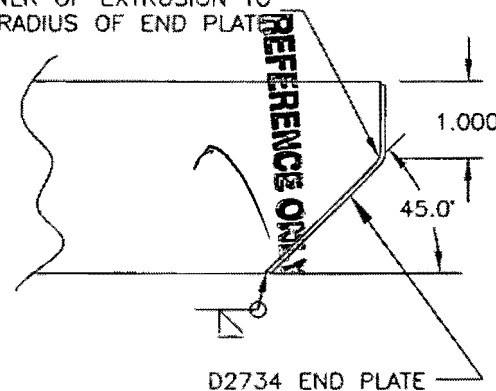
ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

~~D2721-041/-042 STEP ASSEMBLY PARTS LIST~~

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622 TYPICAL S
2) WELD PER DART QSI 004 NOT
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2734 END PLATE

TYPICAL STEP END DETAIL
NOT TO SCALE

RELEASED
8-11-74

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D2724	REV. C SHEET 1 OF 1
DATE 05.09.19	TITLE 206L/407 STEP ASSEMBLY SCALE NTS		
A	97.12.04	NEW ISSUE	
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES	
C	05.09.19	RE-DESIGN, ADD D3458-1/-3	

